

Work Order ID 71887

Wednesday, July 13, 2011 11:09:46 AM



Page 1

Item ID:	D3488-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Blade Fitting Assembly, LH				Stop	
Start Date:	7/14/2011	Start Qty:	12.00			
Required Date:	7/28/2011	Req'd Qty:	12.00			
Reference:						

Approvals:	Process Plan:	<u>ME</u>	Date:	<u>11-07-13</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3488	Rev B

100		0.00							
	DOOSAN LATHE								
Doosan	Memo	0.00							
Doosan Lathe	1-Turn as per Dwg DSK 101 & Folio FA625□2-Deburr								

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

120		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA625 & Dwg D3488□2-Deburr								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

* NOTE: Date & initial all entries

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. The second step is to define the objectives and goals of the project. This involves determining what you want to achieve and how you will measure success.

3. The third step is to develop a plan of action. This involves identifying the steps that need to be taken to achieve the objectives and goals.

4. The fourth step is to implement the plan. This involves putting the plan into action and monitoring progress.

5. The fifth step is to evaluate the results. This involves assessing the outcomes of the project and determining whether the objectives and goals have been achieved.

6. The sixth step is to report on the results. This involves communicating the findings of the project to the relevant stakeholders.

7. The seventh step is to review the process. This involves reflecting on the project and identifying areas for improvement.

8. The eighth step is to document the results. This involves creating a record of the project and its outcomes.

9. The ninth step is to share the results. This involves disseminating the findings of the project to a wider audience.

10. The tenth step is to conclude the project. This involves finalizing all tasks and ensuring that everything is in order.

Page 2

Accept

[illegible]**Setup Start**[illegible]

Stop

1. [REDACTED]

2. [REDACTED]

3. [REDACTED]

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1. **Project Name:** [Project Name]
 2. **Project Number:** [Project Number]
 3. **Project Manager:** [Project Manager]
 4. **Project Sponsor:** [Project Sponsor]
 5. **Project Start Date:** [Project Start Date]
 6. **Project End Date:** [Project End Date]
 7. **Project Location:** [Project Location]
 8. **Project Description:** [Project Description]
 9. **Project Objectives:** [Project Objectives]
 10. **Project Scope:** [Project Scope]
 11. **Project Budget:** [Project Budget]
 12. **Project Risk:** [Project Risk]
 13. **Project Status:** [Project Status]
 14. **Project Approval:** [Project Approval]
 15. **Project Review:** [Project Review]

Cust Item ID:

1. **NAME** _____
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Customer:

Reference:

Run Start

[illegible]

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

[illegible]

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

Hours

2 108/29 SL

[illegible]

QC

Memo

0.00

Quality Control

encl 11/08/30

[illegible]

QC

Memo

0.00

Quality Control

0.00

1. The first step is to identify the key components of the system. This includes understanding the hardware, software, and data involved.

2. The second step is to define the requirements. This involves determining what the system needs to do and what it must be able to handle.

3. The third step is to design the system. This includes creating a detailed plan of how the system will be built and how it will be tested.

4. The fourth step is to implement the system. This involves building the system according to the design and testing it to ensure it meets the requirements.

5. The fifth step is to maintain the system. This involves keeping the system up-to-date and ensuring it continues to meet the requirements.

HandFinish

Memo

0.00

Hand Finishing

12x ~~Ø~~ m-k 11/08/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71887

Wednesday, July 13, 2011 11:09:46 AM



Page 3

Item ID:	D3488-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Blade Fitting Assembly, LH					
Start Date:	7/14/2011	Start Qty:	12.00		Cust Item ID:	
Required Date:	7/28/2011	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat	0.00							
Powder Coating	Memo								
	START TIME: 2:40								
	FINISH TIME: 3:10								
									12x Ø M-11/08/30
170	QC3- Inspect Part Finish	0.00							
	QC	0.00							
Quality Control	Memo								
									12 of M 11/08/10
180	HandFinishing	0.00							
	HandFinish	0.00							
Hand Finishing	Memo								
	Install Inserts as per Dwg D3488								12 of M 11/09/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 71887

Wednesday, July 13, 2011 11:09:46 AM

Page 4

Item ID:	D3488-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Blade Fitting Assembly, LH					
Start Date:	7/14/2011	Start Qty:	12.00		Cust Item ID:	
Required Date:	7/28/2011	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00					11	09	01 (12)
200 	Identify as per dwg & Stock Location: <u>EP-6</u>	0.00							
Packaging Packaging	Memo	0.00					12	24	01 11/09/10
210 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							11/9/10

ME 11-09-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 13, 2011 11:09:43 AM

Page 1

Work Order ID: 71887

Parent Item: D3488-041

Parent Item Name: Blade Fitting Assembly, LH

Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-02-28 JLM
IPP Rev:B As per Rev B 06-03-30 JLM
IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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ALS7-1032-225

Purchased

No

Each

700.0000



48
JL 11/08/10

INSERT

Location

Loc Qty

Loc Code

ST282

700

100896

100

111529

300

111581

300

Y-18

D6103-003

Manufactured

No

Each

21.0000



12

22 11.8.17

Round Billet, Aluminum

Location

Loc Qty

Loc Code

MAT043

21

69901

5

71178

16

71884 11.1

9 4

2
7
3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	71887
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2		Part Number:	D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	+/-0.005	2.147	/		Rq.02	
Ø2.780	+/-0.005	2.778	/		Rq.15	
Ø3.125	+/-0.010	3.123	/			
Ø3.346	+/-0.010	3.345	/			
0.125 x 45°	+/-0.010 x +/-0.1°	.125 x 45°	/			
8.000	+0.030/-0.000	8.005	/			
9.250	+/-0.010	9.250	/			
0.188	+/-0.010	.188	/			
R0.032	+/-0.010	R.032	/			
R0.062	+/-0.010	R.062	/			
Ø0.297	+0.005/-0.001	.300	/			
Ø0.430	+/-0.010	.432	/			
0.100	+/-0.010	.100	/			
0.125	+/-0.010	.130	/			
2.620	+/-0.010	2.617	/			
3.500	+/-0.010	3.500	/			
1.005	+/-0.010	1.005	/			
Ø0.484	+0.005/-0.001	.485	/			
1.180	+/-0.010	1.180	/			
3.150	+/-0.010	3.150	/			
3.070	+/-0.010	3.070	/			
R0.063	+/-0.010	R.063	/			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 71887
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2		Part Number: D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 2 of 2

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	.509	/		Vern J1-3	
0.750	+/-0.010	.752	/		H-G	
1.500	+/-0.010	1.500	/		Vern J1-3	
11.18	+/-0.030	11.181	/		H-G	
R0.062	+/-0.010	.062	/		Rf	
0.125	+/-0.010	.125	/		Vern J1-3	
0.590	+/-0.010	.589	/		H-G	
0.793	+/-0.010	.795	/		H-G	
1.351	+/-0.010	1.351	/		H-G	
1.317	+/-0.010	1.315	/		Vern J1-3	
1.802	+/-0.010	1.804	/		H-G	

Measured by: JL	Audited by: ank	Prototype Approval:	N/A
Date: 11-08-29	Date: 11/08/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-041	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM	

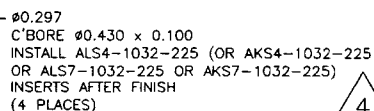
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

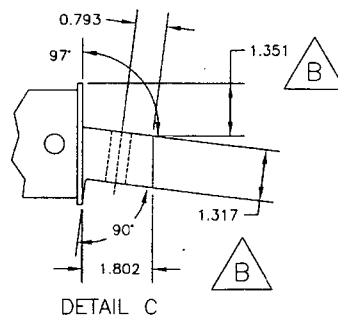
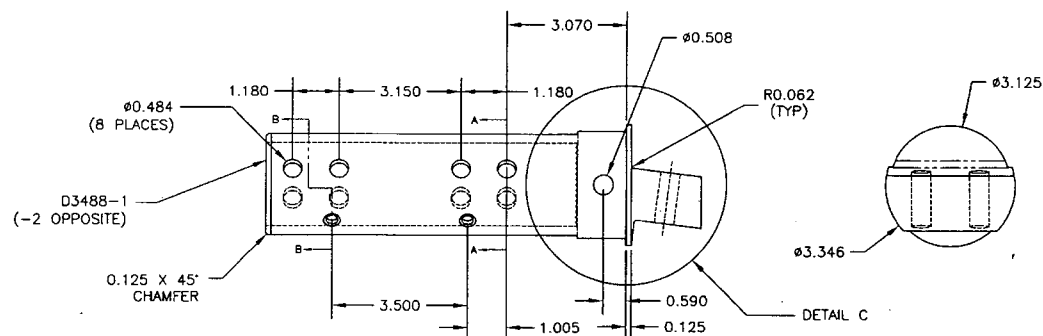
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D3488-041	BLADE FITTING ASSEMBLY (LH)
		D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

- 1) MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR
PER QQ-A-225/9
(REF. DART MATERIAL SPEC M7075T73R)
- 2) FINISH: ACID ETCH, ALDINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) INSTALL INSERTS AFTER POWDER COAT
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3488-041 SHOWN (D3488-042 OPPOSITE)

RELEASED
OCT 03 1977
PER OS
EIN #739

7188

B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	<i>PH</i> DRAWN BY <i>PH</i>	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	<i>#</i> APPROVED <i>#</i>	DRAWING NO. D3488
DATE	06.03.15	TITLE BLADE FITTING
		REV. 1 OF 1 SHEET 1 OF 1 SCALE 1:

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries